

Date: Thursday, 2/8/2007 12:42:50 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LATCH BRACKET
Job Number	: 30716		
Estimate Number	: 10994		
P.O. Number	: N/A	Part Number	: D2583
This Issue	: 2/8/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2583 REV. B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 28018	Drawing Revision	: B
		Material	: N/A
		Due Date	: 3/15/2007
Written By	:	Qty:	100
Checked & Approved By	:	Um:	Each
Comment	: Est: 00.11.01 Removed P/O for Powder Coat- in house processDM		
	: Est: D 06.07.21 Waterjet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.1227 sf(s)/Unit Total: 12.2745 sf(s)
 Material: 5052-H32 (QQ-A-250/8) 0.040" thick 9.9381 (grain direction 45°)
 (M5052H32S040) Batch: m102448 x81 m102723 x18 2.2086

(100)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2583
 Dwg Rev: B
 Prog Rev: B

ml 07 03 13

(100)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 03 13

(100)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07 03 14

(99)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Deburr
 Form on CNC Brake as per Dwg D2583

7
 07/04/18
 SB 07/04/19


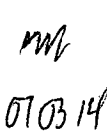
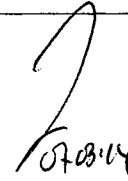
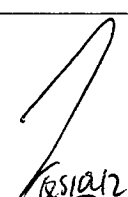
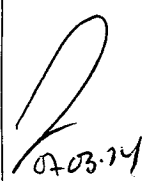
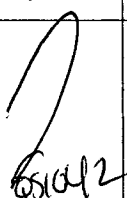


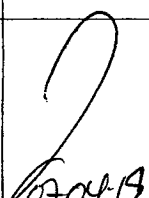
P/O

(97)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/17

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/14	2.0 3.0	1 part fell into the tube Tub.	 07/03/14	Qty 99 remain	 07/03/14	 07/03/14	 07/03/14	 07/03/14
07/04/18	5	2 piece scrap at the cabin	 07/04/18	Scrap + destroy		 07/04/18	 07/04/18	 07/04/18

NOTE: Date & initial all entries

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Drawing Name: LATCH BRACKET

Job Number: 30716

Part Number: D2583

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-04-23
QSP019

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.A. 07/04/24
(97X)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MS 07-04-25 (97)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CP 07/04/26 (97)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP 07/04/26 (97)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

CP 07/04/27 (97)

Job Completion



U 07-04-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

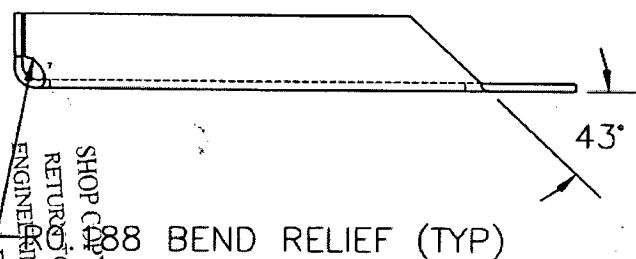
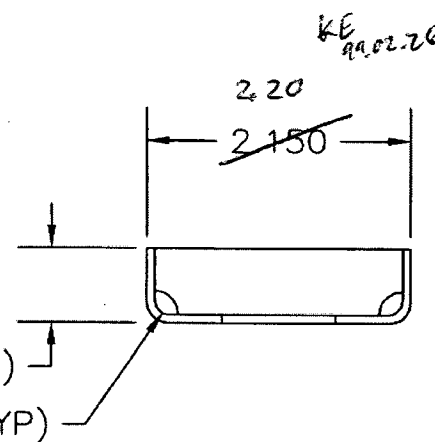
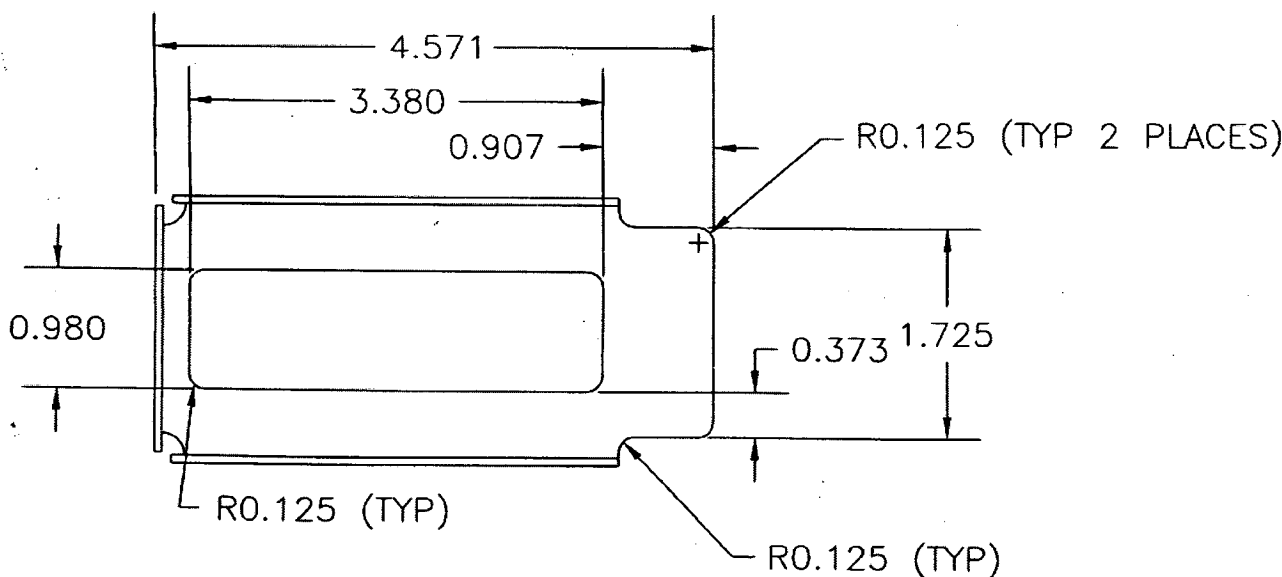
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
KE 99.02.25

DESIGN	MIKE M.	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED	CP	APPROVED	KE	HAWKESBURY, ONTARIO, CANADA
DATE	99.02.22	TITLE	D2583	REV. B
			LATCH BRACKET	SHEET 1 OF 1
A	96.07.10	NEW ISSUE		SCALE
B	99.02.22	CHANGE OF FINISH (PER TSR A887)		2:3



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

